

Work Order ID 63823

Tuesday, November 16, 2010 1:25:34 PM

Page 1

Item ID: D350-636-012

Accept

Revision ID:

Item Name: Skidtube RH

Start Date: 11/15/2010 Start Qty: 1.00

Required Date: 11/30/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 10/11/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

HJ for BG 10-12-8

B63823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Date:

SPC (Y/N):

Date:

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

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Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

10/11/23

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Page 3

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐ M115778 BE 10/11/23

12-Grind welds flush as per Dwg D2750

BB 10/11/25

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

6/10/12/5

130



QC

Quality Control

QC5- Inspect part completeness to step on 'W/O

0.00

Memo

0.00

6/10/12/5

40

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Page 4

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	Memo				1	0		BE 10/11/25
	Hand Finishing								
150	QC3- Inspect Part Finish	0.00							
	QC	Memo							
	Quality Control								

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PS								

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Tuesday, November 16, 2010 1:25:34 PM



Page 5

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ Sikaflex-291 batch: M116010 ☐☐☐
exp. date: 11-09-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod batch: M115778

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

BE 10/11/29

BE 10/12/01

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Page 6

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

BE 10/12/01

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/12/01

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/12/01

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Page 7

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

=> M 10/12/03

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951.

Memo

0.00

START TIME: 10:50
OVEN TEMPERATURE: 320°
FINISH TIME: 11:20

1 10-12-7.

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/12/08

Memo

0.00

Inspect for foreign object per QSI 024

1 0

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Page 8

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

HandFinishing

0.00

=) H 10/12/08

0.00

Memo

Hand Finishing

✓ Install inserts as per dwg D2750

1 0

230



HandFinish

HandFinishing

0.00

=) H 10/12/08

0.00

Memo

Hand Finishing

✓ 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: N/A3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: M115114EXP DATE: 11/10

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

✓ A/R 55-o-ring lube batch: M114189

5-Coat all exposed fasteners with "LPS Procyon"

✓ batch: M114596

1 0

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Page 9

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

10/12/85 10 11 08 (1)

250

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

10/12/85

260

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

10 12 10 (1)

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Page 10

Tuesday, November 16, 2010 1:25:34 PM

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00



Packaging

0.00

Packaging

Memo

Packaging

Package as per PPP D350-636-012

Loc 72 Rev I

10/12/1389

280

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

10/12/14

u 10.12.14

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Page 1

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as
 per IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225

Purchased

No

220

Each

4,520.000

38

38



Insert



HL 10/12/08

Location

Loc Qty

Loc Code

PK011

4520

110768

4520

x38

AN3C5A

Purchased

No

230

Each

888.0000

34

34



Bolt



HL 10/12/08

Location

Loc Qty

Loc Code

ST350

878

114330

11

115015

13

115371

100

115422

100

115594

282

115835

372

x34

ST351

10

113121

10

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Tuesday, November 16, 2010 1:25:44 PM

Page 2

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Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C6A



BOLT

Purchased

No

230

Each

245.0000

4

4



10/12/08

Location

Loc Qty

Loc Code

ST351

245

111982

245

yl

AN6C44A



BOLT

Purchased

No

230

Each

119.0000

4

4



10/12/08

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

117

111649

2

114653

1

114941

64

115936

50

yl

AN8C35A



BOLT

Purchased

No

230

Each

54.0000

1

1



10/12/08

Location

Loc Qty

Loc Code

ST346

54

114442

5

115188

22

115960

27

yl

AN960C10L

NAS1149C0332
R-



washer

Purchased

No

230

Each

25.0000

38

38



10/12/08

Location

Loc Qty

Loc Code

ST245

25

107534

25

M115832

x38

Tuesday, November 16, 2010 1:25:44 PM

Shop Packet Print

Page 2

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Tuesday, November 16, 2010 1:25:44 PM

Page 3

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Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230 Each

0.0000

1

1



XNASIWA08332R / M114915



xl M 10/12/08

WASHER

D2745

Manufactured No

230 Each

265.0000

8

8



M 10/12/08

Bushing

Location

Loc Qty

Loc Code

ST023

265

52311

5

59112

4

61203

44

61988

104

63315

108

y8

D3488-042

Manufactured No

230 Each

24.0000

1

1



M 10/12/08

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

15

59643

5

62003

10

FP18

9

61690

9

xl

D3492-041

Manufactured No

230 Each

76.0000

8

8



M 10/12/08

Plug Assembly

Location

Loc Qty

Loc Code

FP013

76

59114

1

61987

14

62210

61

y8

Tuesday, November 16, 2010 1:25:44 PM

Shop Packet Print

Page 3

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D3492-043



Plug Assembly

Manufactured No

230 Each

85.0000 8 8



11/12/08

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

83

59117

1

59190

4

62663

78

11/12/08

D3535-25



Wearshoe

Manufactured No

230 Each

21.0000 1 1



11/12/08

Location

Loc Qty

Loc Code

FP18

21

62033

7

62233

14

11/12/08

D3536-25



Gasket

Manufactured No

230 Each

4.0000 1 1



11/12/08

Location

Loc Qty

Loc Code

FP12

4

61707

4

B63857

11/12/08

D3537-1



Wearpad

Manufactured No

230 Each

27.0000 3 3



11/12/08

Location

Loc Qty

Loc Code

FP017

27

62661

9

63313

18

B63545

11/12/08

Tuesday, November 16, 2010 1:25:44 PM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3631-1



Washer

Manufactured No

230 Each

281.0000 8 8



10/12/08

Location

Loc Qty

Loc Code

ST072

281

60755

81

63647

200

x8

D3672-1



Phenolic Washer

Manufactured No

230 Each

667.0000 4 4



10/12/08

Location

Loc Qty

Loc Code

ST077

667

42329

10

52505

657

x4

D3791-1



Wearplate

Manufactured No

230 Each

19.0000 1 1



10/12/08

Location

Loc Qty

Loc Code

FP17

19

61702

7

62239

12

x1

D3793-1



Wearshoe

Manufactured No

230 Each

16.0000 1 1



10/12/08

Location

Loc Qty

Loc Code

FP18

16

59151

1

59630

1

61244

1

61710

13

x1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Page 6

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-3



Wearshoe

Manufactured No

230 Each

13.0000

1 1



11/10/12/08

Location

Loc Qty

Loc Code

FP18

12

61711

12

X1

FP19

1

57947

1

D3794-1



Gasket

Manufactured No

230 Each

20.0000

1 1



11/10/12/08

Location

Loc Qty

Loc Code

FP010

20

61704

20

X1

D3794-3



Gasket

Manufactured No

230 Each

25.0000

1 1



11/10/12/08

Location

Loc Qty

Loc Code

FP10

24

60826

1

61712

23

X1

FP18

1

59153

1

MS21043-6



NUT

Purchased No

230 Each

618.0000

4 4



11/10/12/08

Location

Loc Qty

Loc Code

ST301

618

112314

618

V4

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Page 7

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8



NUT

Purchased

No

230

Each

87.0000

1

1



10/12/08

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

x1

NAS1611-010



O-RING

Purchased

No

230

Each

309.0000

8

8



10/12/08 PTO=7

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013



O-RING

Purchased

No

230

Each

228.0000

8

8



10/12/08

Location

Loc Qty

Loc Code

FP

228

115460

100

115589

28

115812

100

x8

Tuesday, November 16, 2010 1:25:44 PM

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Page 7

W/O: 63823		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/08	230	Replace NAS1611-D10 "O" rings for D2594-3 / M61762 "O" rings	<i>[Signature]</i>	10/12/08	1		

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Page 8

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN8C21A



BOLT

Purchased No 250 Each 45.0000

2 10/12/08

Location Loc Qty Loc Code

ST345 45

113558 1

114653 4

115723 40

Purchased No 250 Each 123.0000

2 10/12/08

Location Loc Qty Loc Code

ST348 123

106043 123

Manufactured No 250 Each 25.0000

1 10/12/08

Location Loc Qty Loc Code

ST466 25

60210 25

Manufactured No 250 Each 36.0000

2 10/12/08

Location Loc Qty Loc Code

ST062 36

61672 36

2

AN960JD816



1/2" washer, Alum

D2741



Blade, 350 Skidtube

D3493-1



Washer

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Page 9

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1



Spacer

Manufactured No

250

Each

47.0000

2 2
10/12/10

Location

Loc Qty

Loc Code

ST065

47

61673

5

62218

42

2

D3672-13



Phenolic Washer

Purchased No

250

Each

792.0000

2 2

Location

Loc Qty

Loc Code

ST077

792

54363

792

Purchased No

250

Each

87.0000

1 3
10/12/10

MS21083C8



NUT

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

2

D2600-3-BENT



Extrusion Bent

Manufactured No

110

Each

13.0000

1 1

Location

Loc Qty

Loc Code

LG

13

61634

4

62594

8

62764

1

1

BB 10/11/23

Tuesday, November 16, 2010 1:25:44 PM

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:25:44 PM

Page 10

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2744



Cap

Manufactured No 110 Each 39.0000 1 1



Location

Loc Qty

Loc Code

LG

6

59198

6

ST

33

62715

33

[Handwritten signature]

1 BE 10/11/23

D2739



350 I Beam

Manufactured No 160 Each 12.0000 1 1



Location

Loc Qty

Loc Code

LG

12

62563

8

62688

4

1 BE 10/11/29

D2743



Crossbolt Spacer

Manufactured No 160 Each 150.0000 8 8



Location

Loc Qty

Loc Code

LG

150

50281

10

57953

2

59111

31

61844

107

8 BE 10/11/30

D3490-3



Cross Bolt Spacer

Manufactured No 160 Each 39.0000 4 4



Location

Loc Qty

Loc Code

LG

39

60294

1

62668

38

4 BE 10/11/30

Tuesday, November 16, 2010 1:25:44 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval: QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

Tuesday, November 16, 2010 1:25:44 PM

Work Order ID: 63823

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

95.0000

4

4



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

95

59424

3

61217

2

62450

90

4

BE 11/11/30

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Page 11

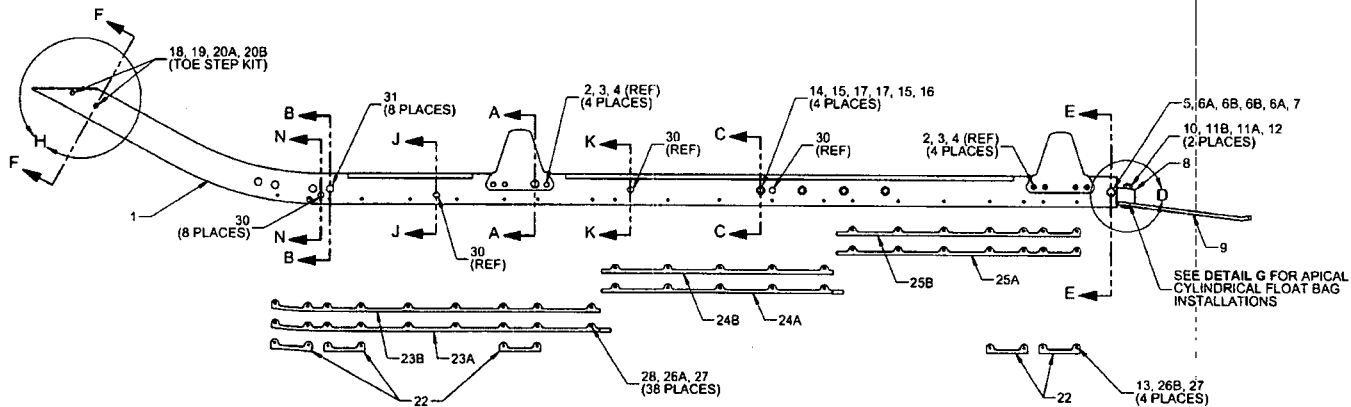
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

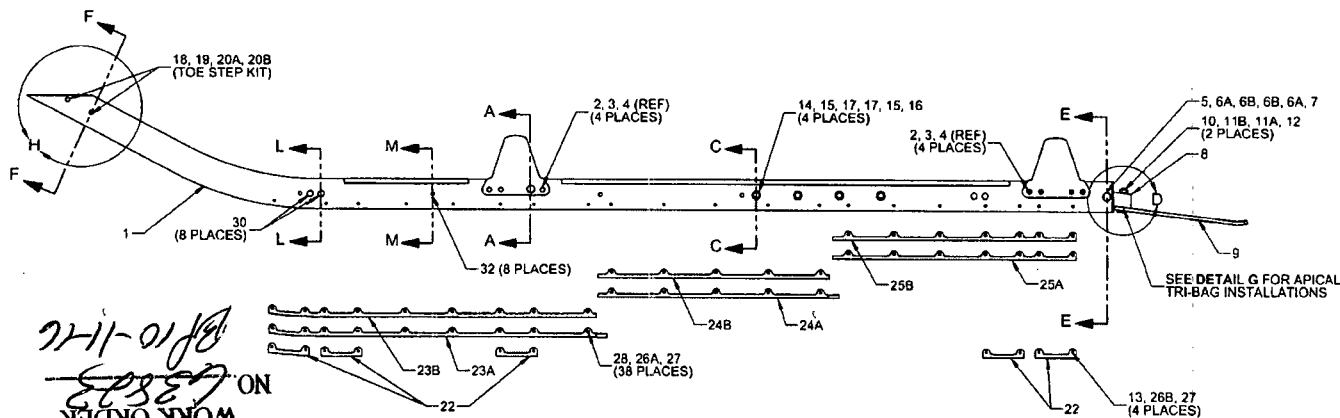
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-636-011/-012 ASSEMBLY
(Aerazur / Apical Cylindrical)



D350-636-013/-014 ASSEMBLY
(Aircruiser / Apical Tri-Bag)

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WORK ORDER
NO. 13823

Figure 1: D350-636-011/-012/-013/-014 SKIDTUBE ASSEMBLY AT CHG 003

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Revision: H

Date: 10.07.26

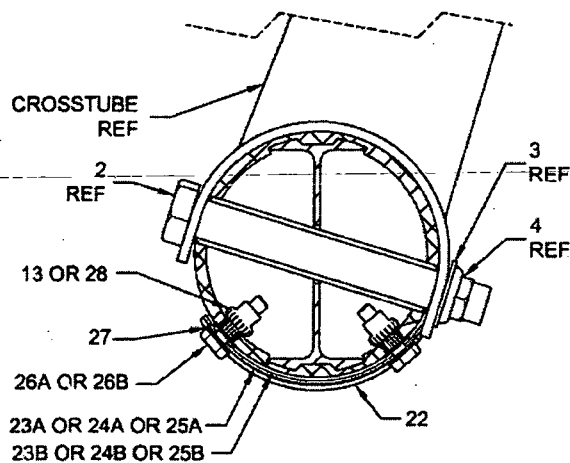
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

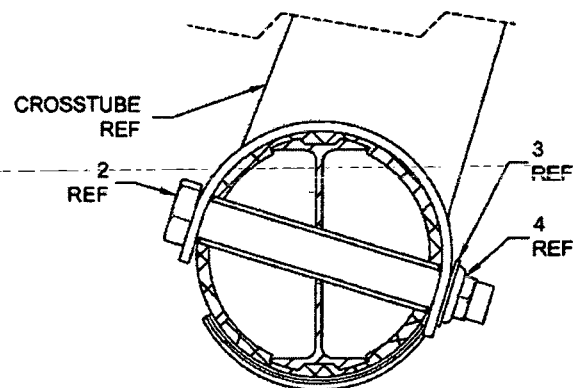
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

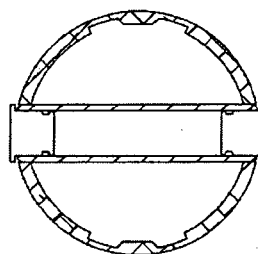
NOTE: Date & initial all entries



SECTION A-A
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)

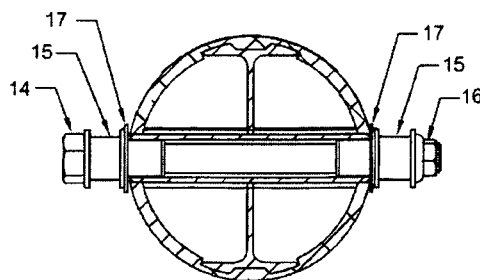


SECTION P-P
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)



SECTION B-B
(SECTION J-J, K-K, L-L AND M-M SIMILAR)
8 PL PER SKIDTUBE

21043823



SECTION C-C
4 PL PER SKIDTUBE

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Revision: H
Date: 10.07.26

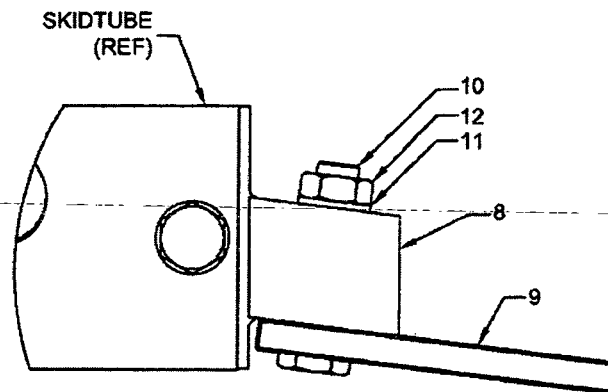
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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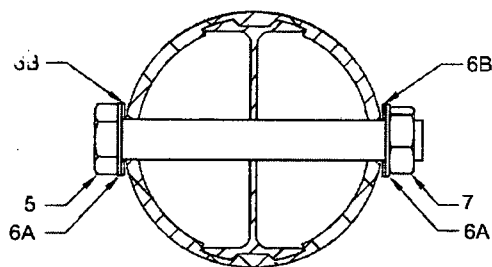
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

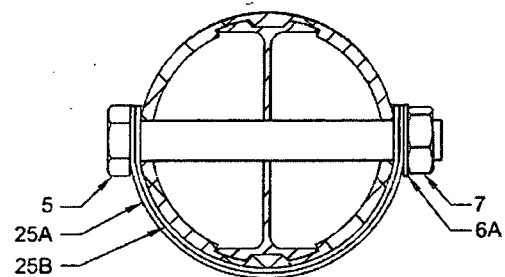


DETAIL D
1 PL PER SKIDTUBE

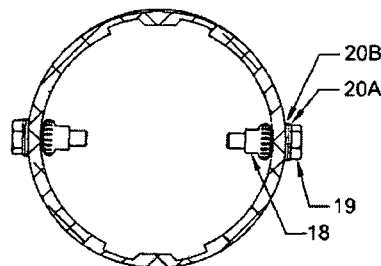
w/0 43822



SECTION E-E
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)



SECTION Q-Q
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)



SECTION F-F
2 PL PER SKIDTUBE

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Revision: H
Date: 10.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

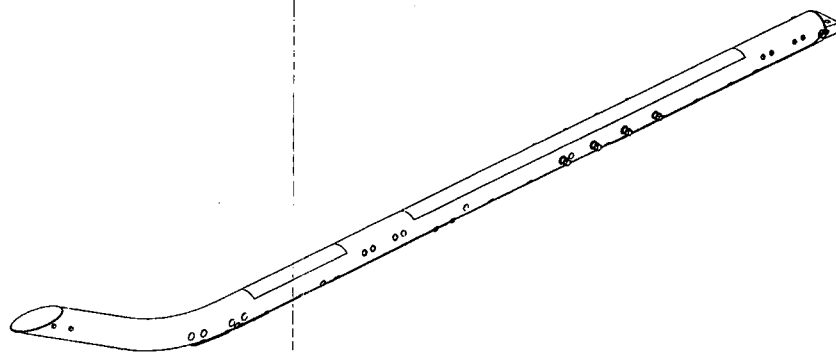
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
 - ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 - MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 - MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
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BJ10-1119

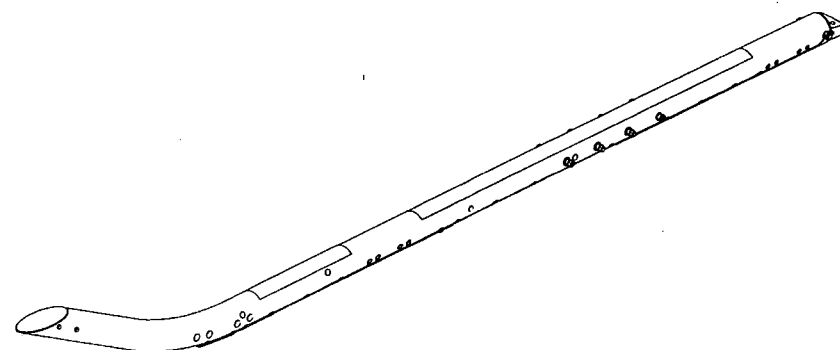
RELEASED
08-07-16

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE USA, INC.	
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CHECKED	<u>PH</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>PH</u>	D2750	SHEET 1 OF 11
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	350 SKIDTUBE ASSEMBLY	NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

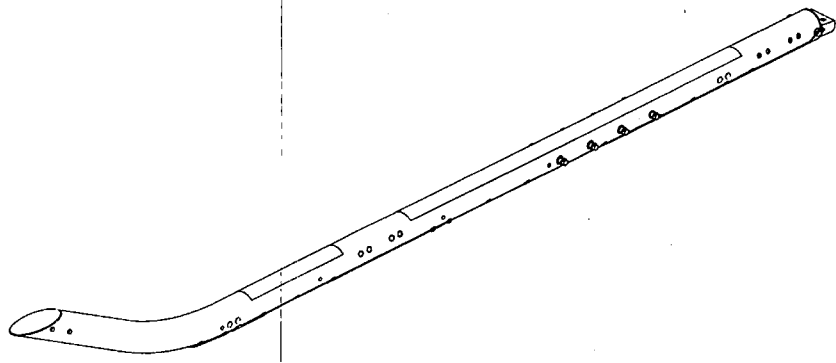


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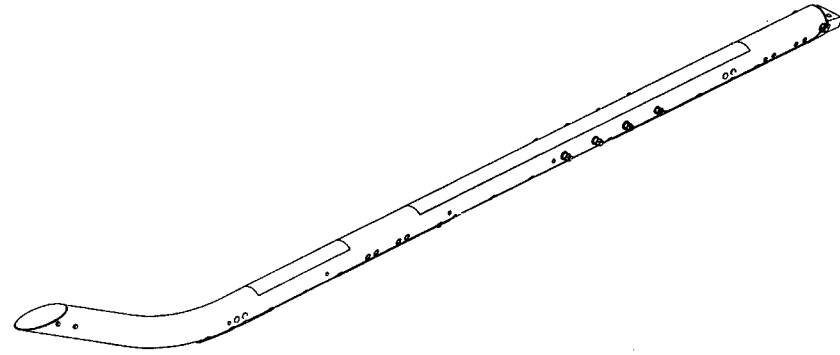
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18 JUL 77

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MFG. APPR.	NA	D2750	SHEET 2 OF 11
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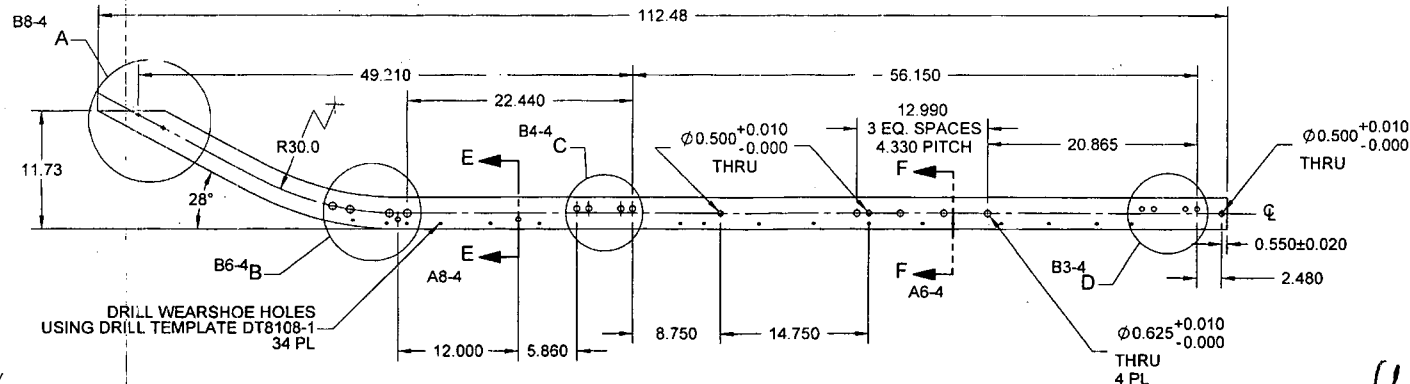
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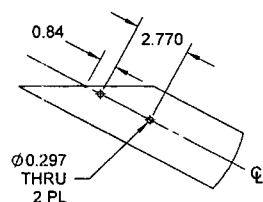
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68-9-22/111

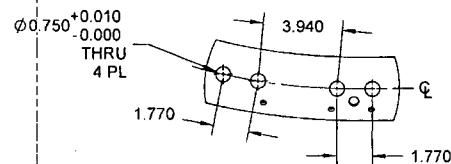
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DRAWN	<i>PD</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
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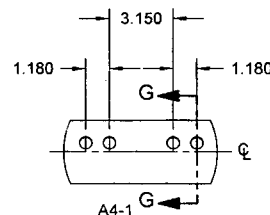
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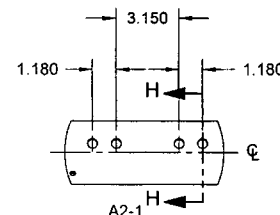
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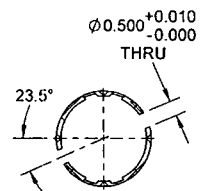
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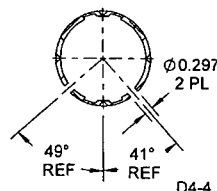
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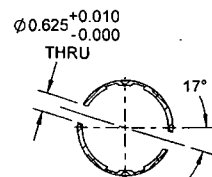
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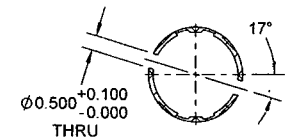
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

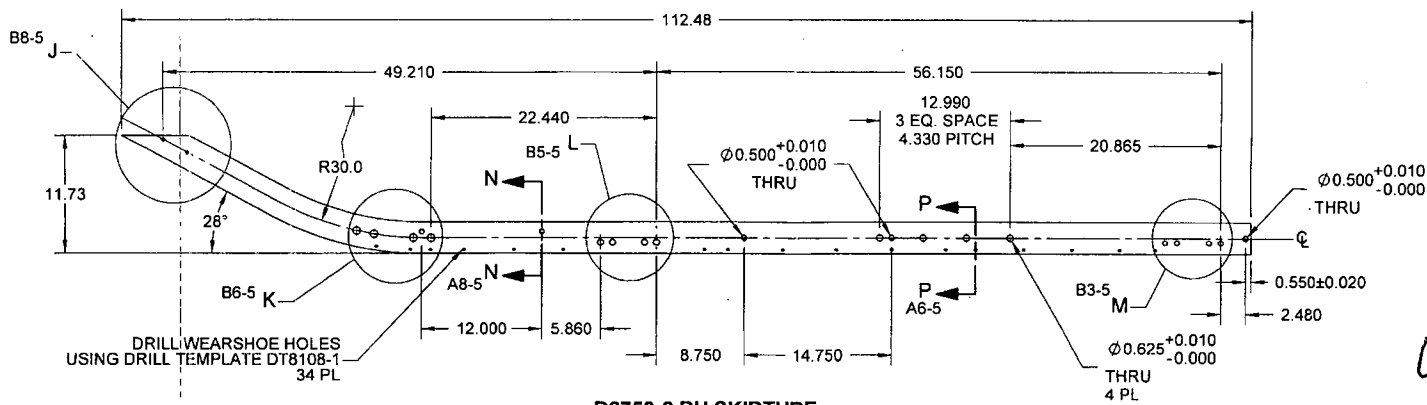


SECTION H-H
SCALE 3X, 4 PL

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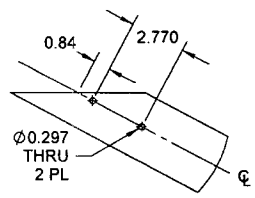
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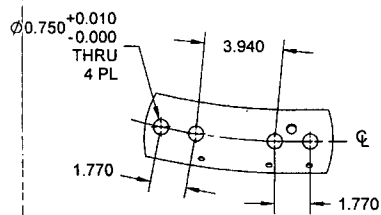


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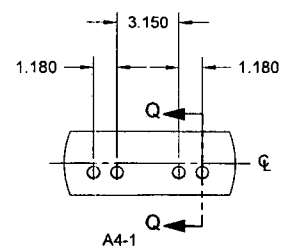
D2750-2 RH SKIDTUBE



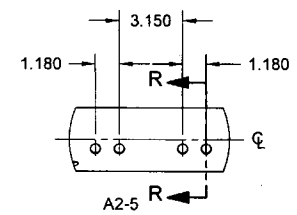
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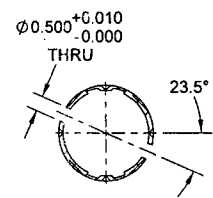
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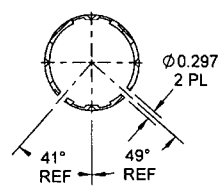
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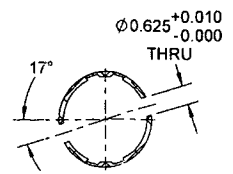
DETAIL M
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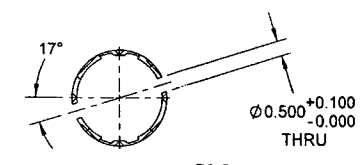
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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8

7

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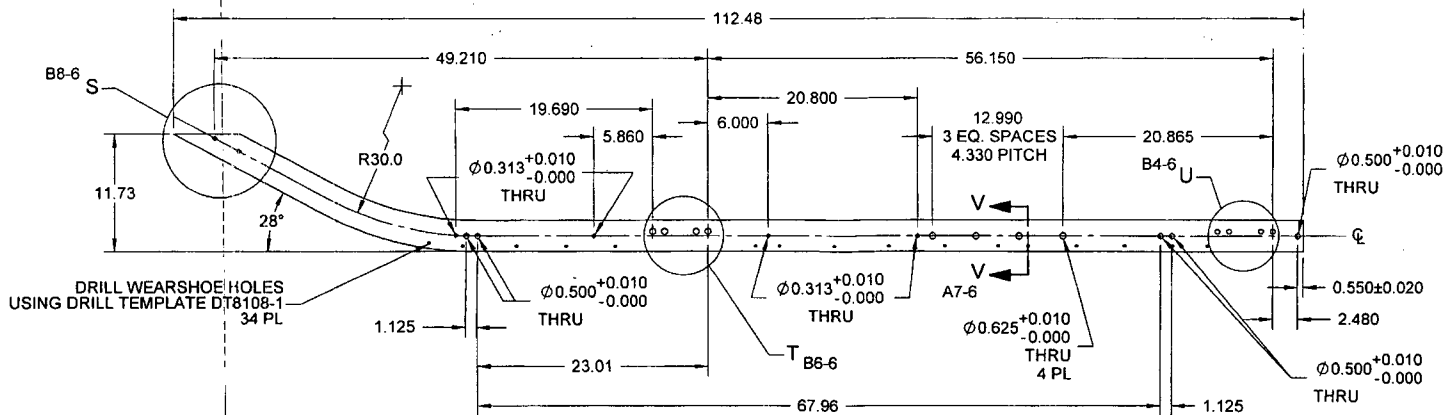
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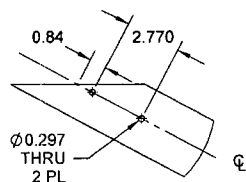
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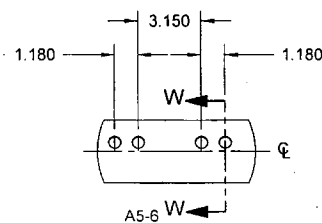
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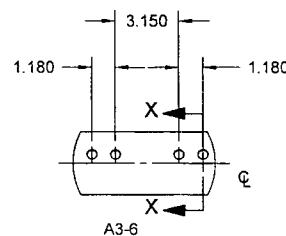
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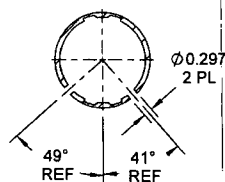
D8-6
DETAIL S
SCALE 2X



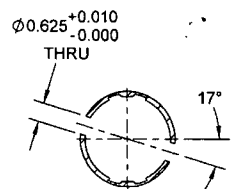
C5-6
DETAIL T
SCALE 2X



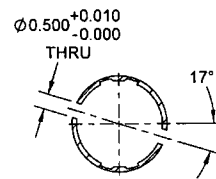
D3-6
DETAIL U
SCALE 2X



C4-6
SECTION V-V
SCALE 3X, 17 PL



B6-6
SECTION W-W
SCALE 3X, 4 PL

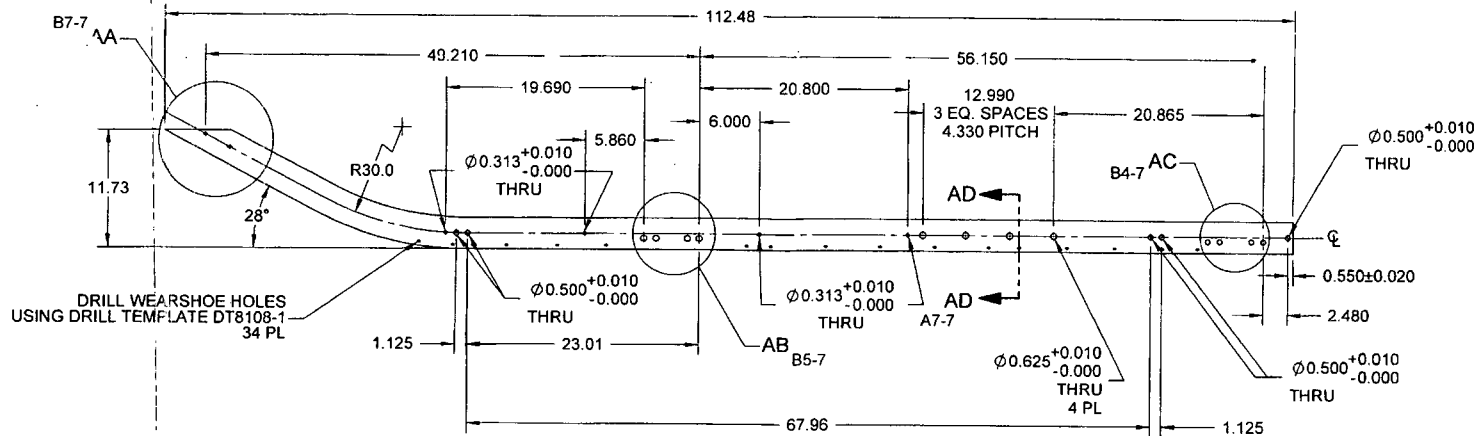


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SECTION X-X
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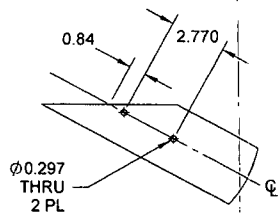
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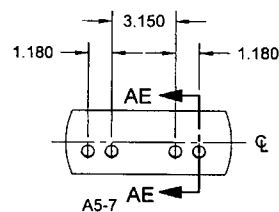
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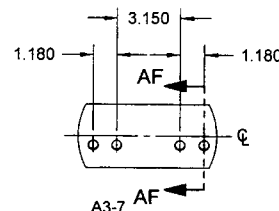
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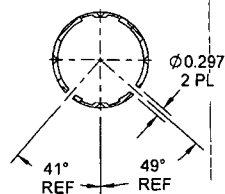
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SCALE 2X



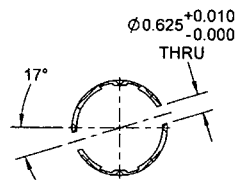
DETAIL AB
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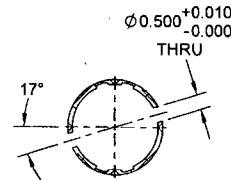
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



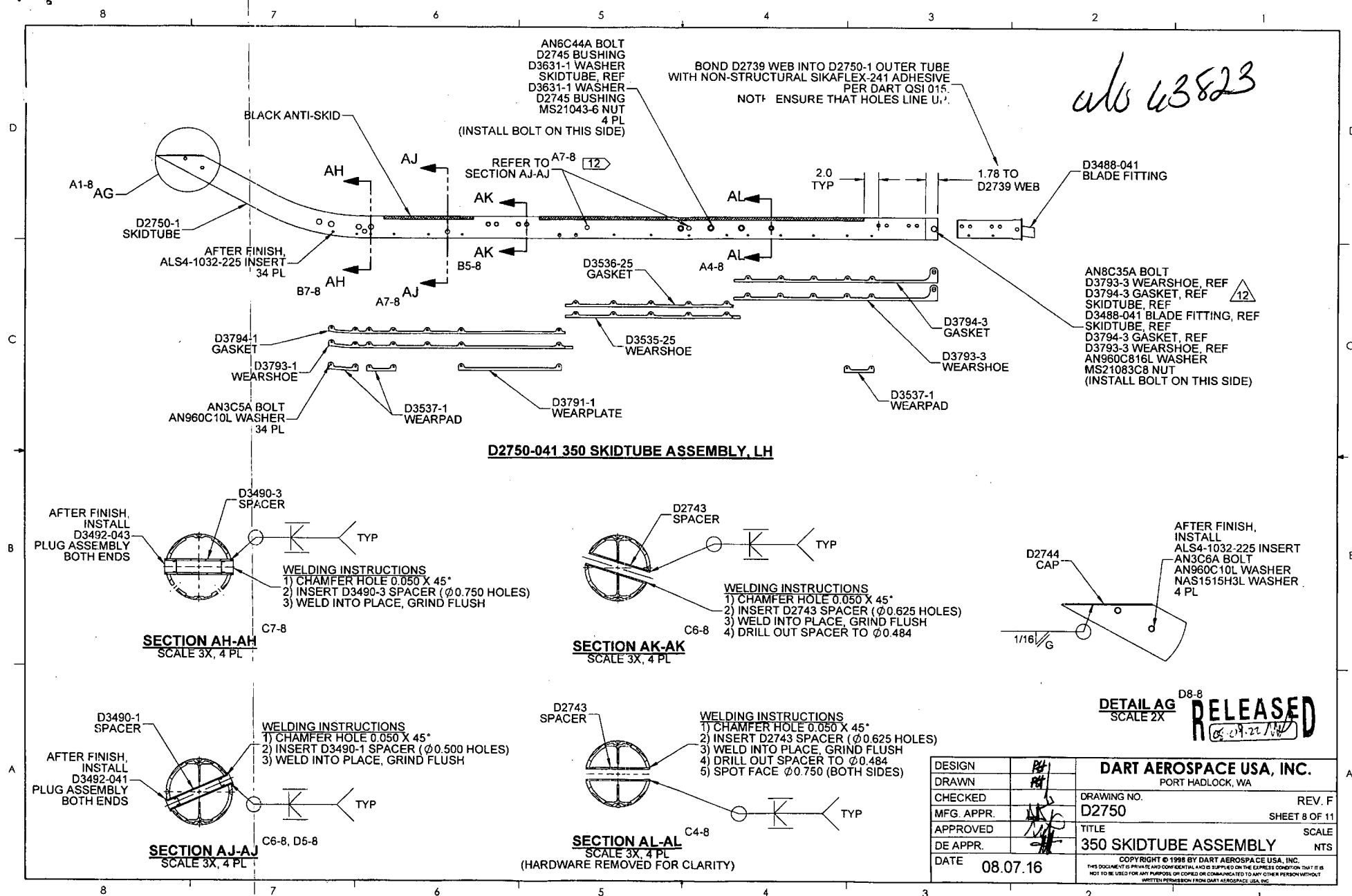
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w/ 43823

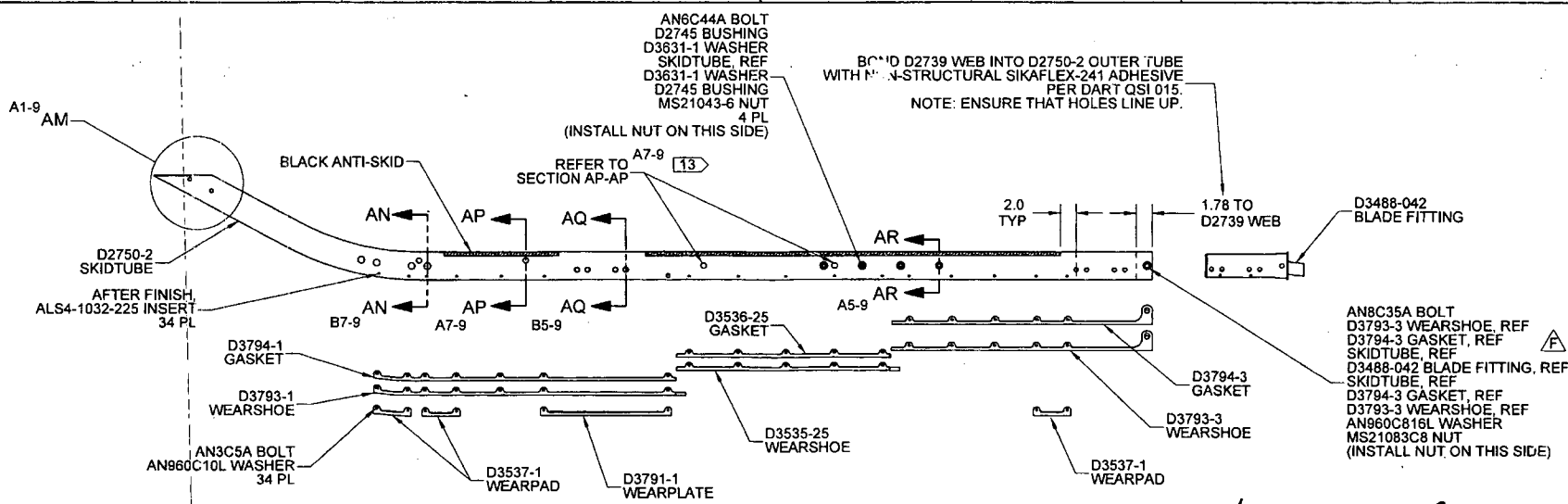
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DE APPR.	PA	TITLE 350 SKIDTUBE ASSEMBLY
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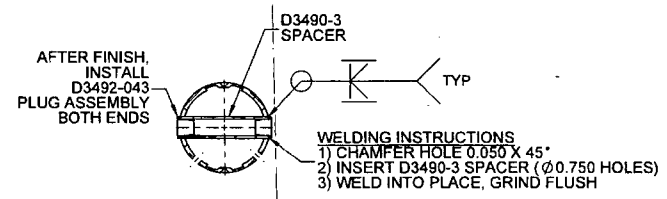


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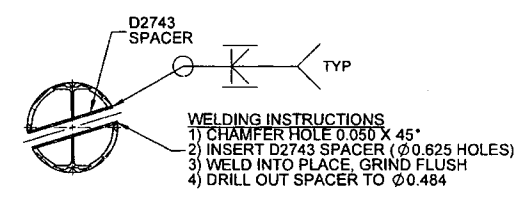


D2750-042 350 SKIDTUBE ASSEMBLY, RH

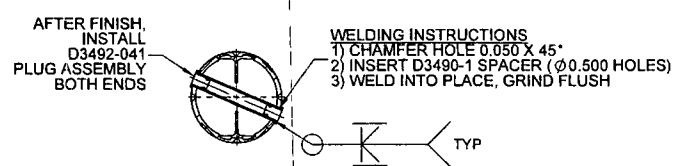
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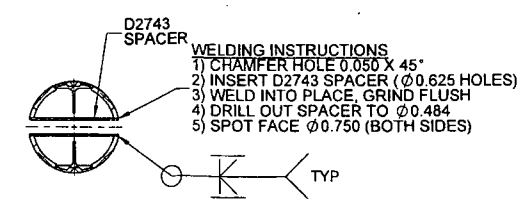
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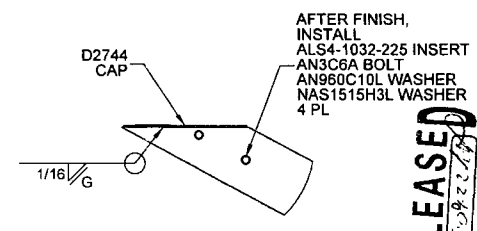
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SECTION AP-AP
SCALE 3X, 4 PL



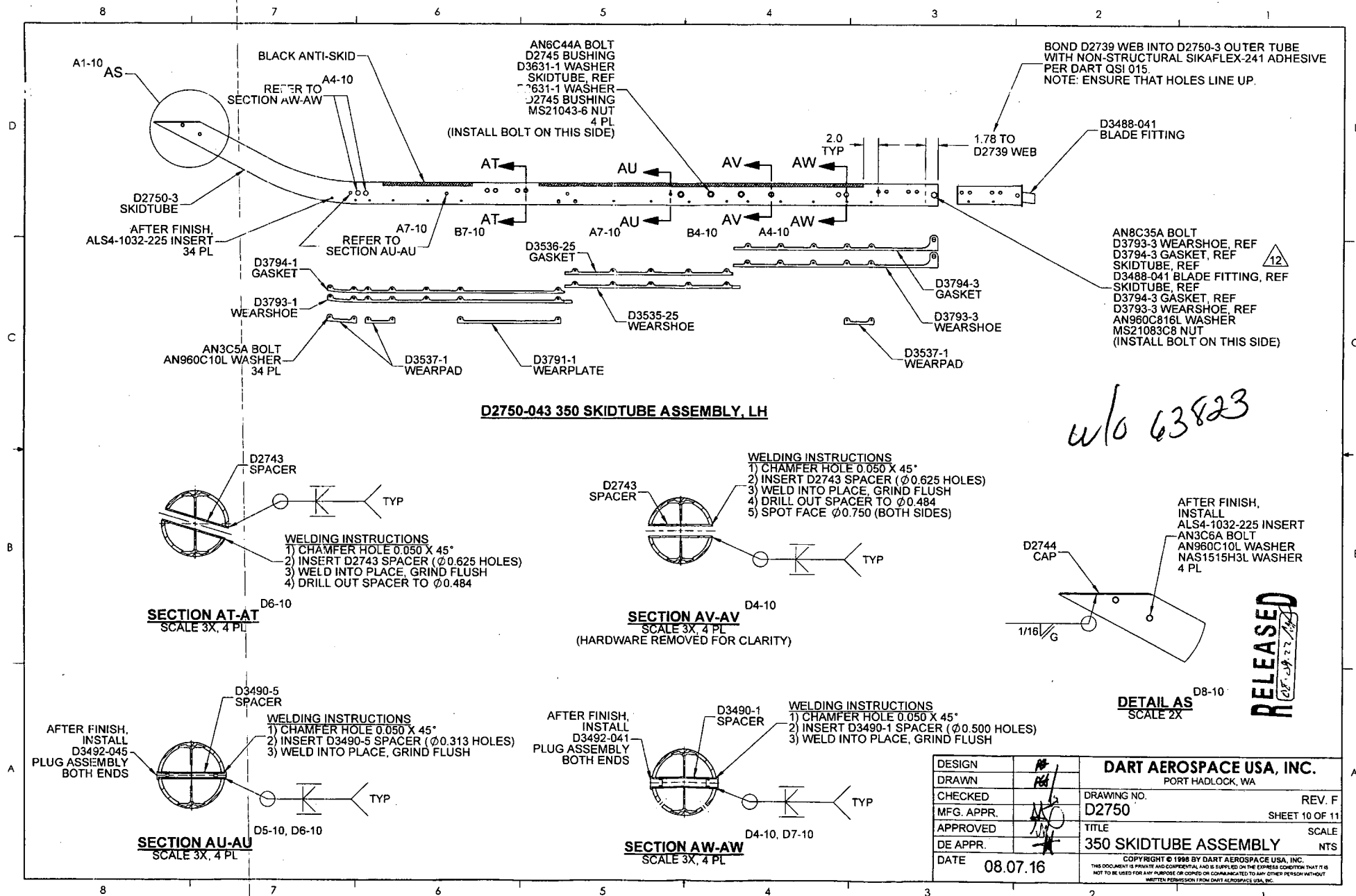
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(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

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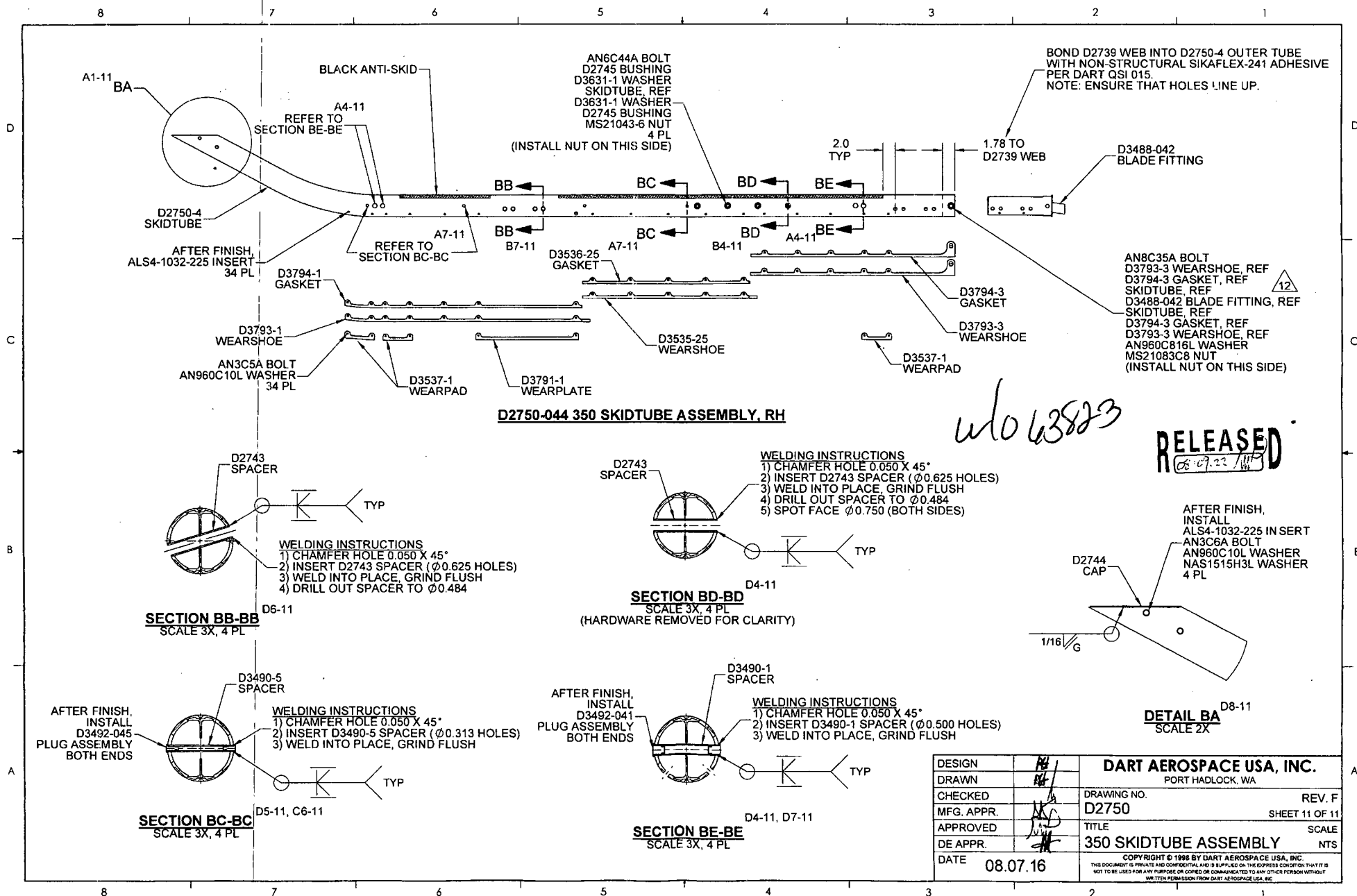
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CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 9 OF 11
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MFG. APPR.	REV. F	D2750	SCALE
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NO. 239

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 6194 6191N
Part number: D350-636-012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Dept Date of Test Coupon 10.09.30
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld